

Work Order ID 74055

Wednesday, September 21, 2011 9:05:48 AM



~~PRELIMINARY~~

Page 1

Item ID: D3806-5

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3806

Rev A

[Handwritten: P02, 11.10.11, CECN 11-640]

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

[Handwritten: 11/10/03, SL]

[Handwritten: 20, 6]

1-Cut as per Dwg D3806

Dwg Rev: _____

Prog Rev: _____

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

[Handwritten: 11/10/03, SL]

[Handwritten: 20, 6]

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74055

Wednesday, September 21, 2011 9:05:48 AM

Page 2

Item ID: D3806-5

Accept

Revision ID:

Item Name: Bar

Setup Start

Stop

Start Date: 9/21/2011 Start Qty: 20.00

Required Date: 9/29/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

22 11-10-03

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 11/09/11

RELEASED 11/09/11

PRELIMINARY ISSUE

POSITIVE RECALL

DATE 11/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 9:05:45 AM

Page 1

Work Order ID: 74055

Parent Item: D3806-5

Parent Item Name: Bar



Start Date: 9/21/2011

Required Date: 9/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
IPP Rev:B 08-09-23 redesign DD verified by:EC
IPP Rev:C 08-12-05 chg mat. thickness DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X2.500		Purchased	No			100	f	13.0870	0.93	19.57895			
304 BAR .500 x 2.50													

Location

Loc Qty

Loc Code

MAT050

13.087

112764

8.312

116135

0.375

117685

4.4

(3) M117000
by A 9050

3954
46.33

P.K. 11/09/11

M304B.500X.250
Jwd 11.10.07

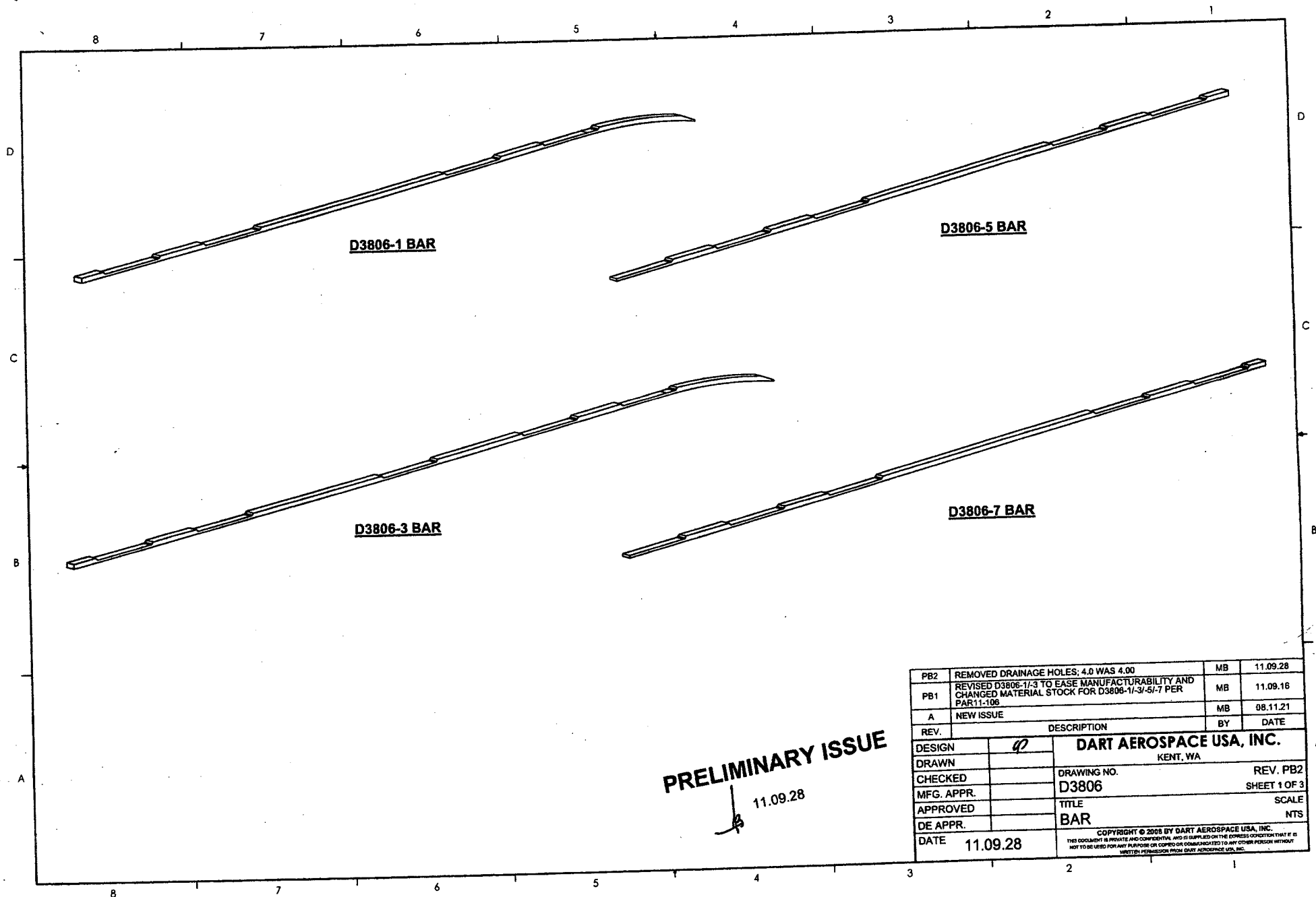
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PB2	REMOVED DRAINAGE HOLES; 4.0 WAS 4.00	MB	11.09.28
PB1	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY AND CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-106	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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8

7

6

5

4

3

2

1

0.500
REF

1.17

0.050

1.00

R31.7

A4-2

35.68 TO BEND TANGENT

43.50 (FLAT LENGTH: 43.60)

D3806-1 BAR

32.50

25.50

8.50

PB2

4.0
TYP

1.50

0.250
REF0.500
REF

1.17

0.050

1.00

R31.7

A4-2

41.75 TO BEND TANGENT

49.60 (FLAT LENGTH: 49.70)

D3806-3 BAR

38.50

31.50

21.50

8.50

PB2

4.0
TYP

1.50

0.250
REF**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs

0.130

135°

PRELIMINARY ISSUE

11.09.28

DETAIL A
TYP, SCALE 2XD5-2
B6-2
C3-3
A3-3

R0.13

2 PL

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 2 OF 3
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8

7

6

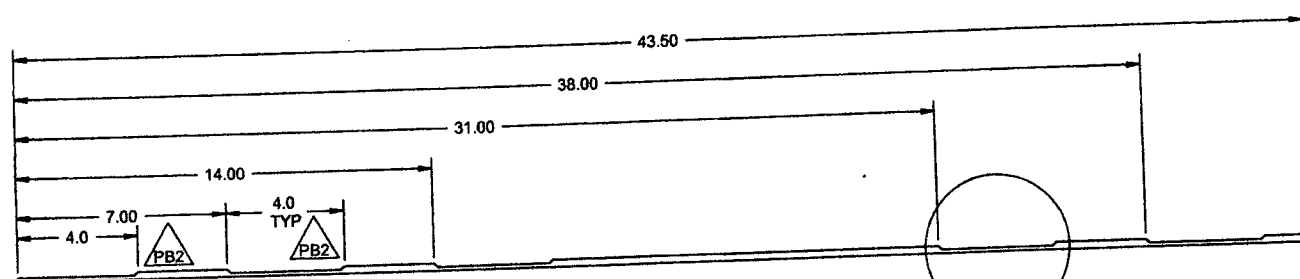
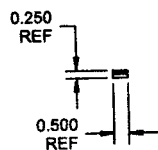
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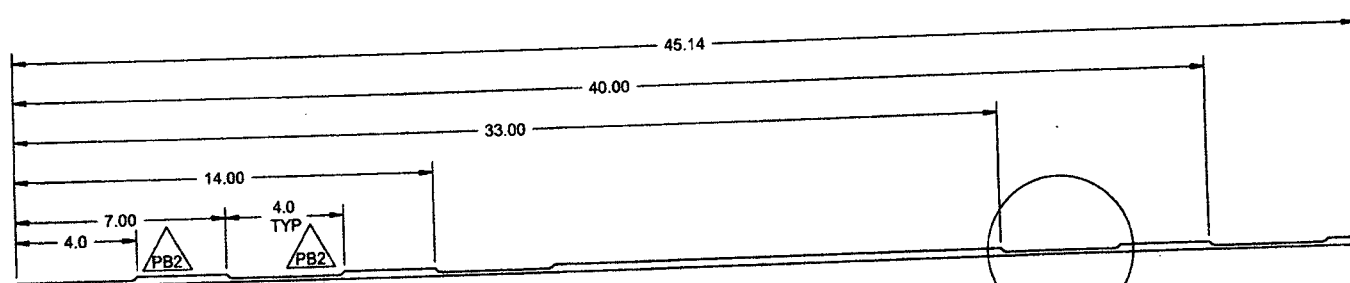
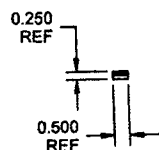
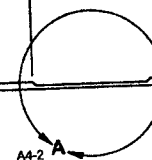
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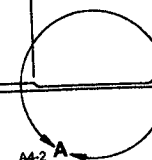
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D3806-5 BAR



D3806-7 BAR



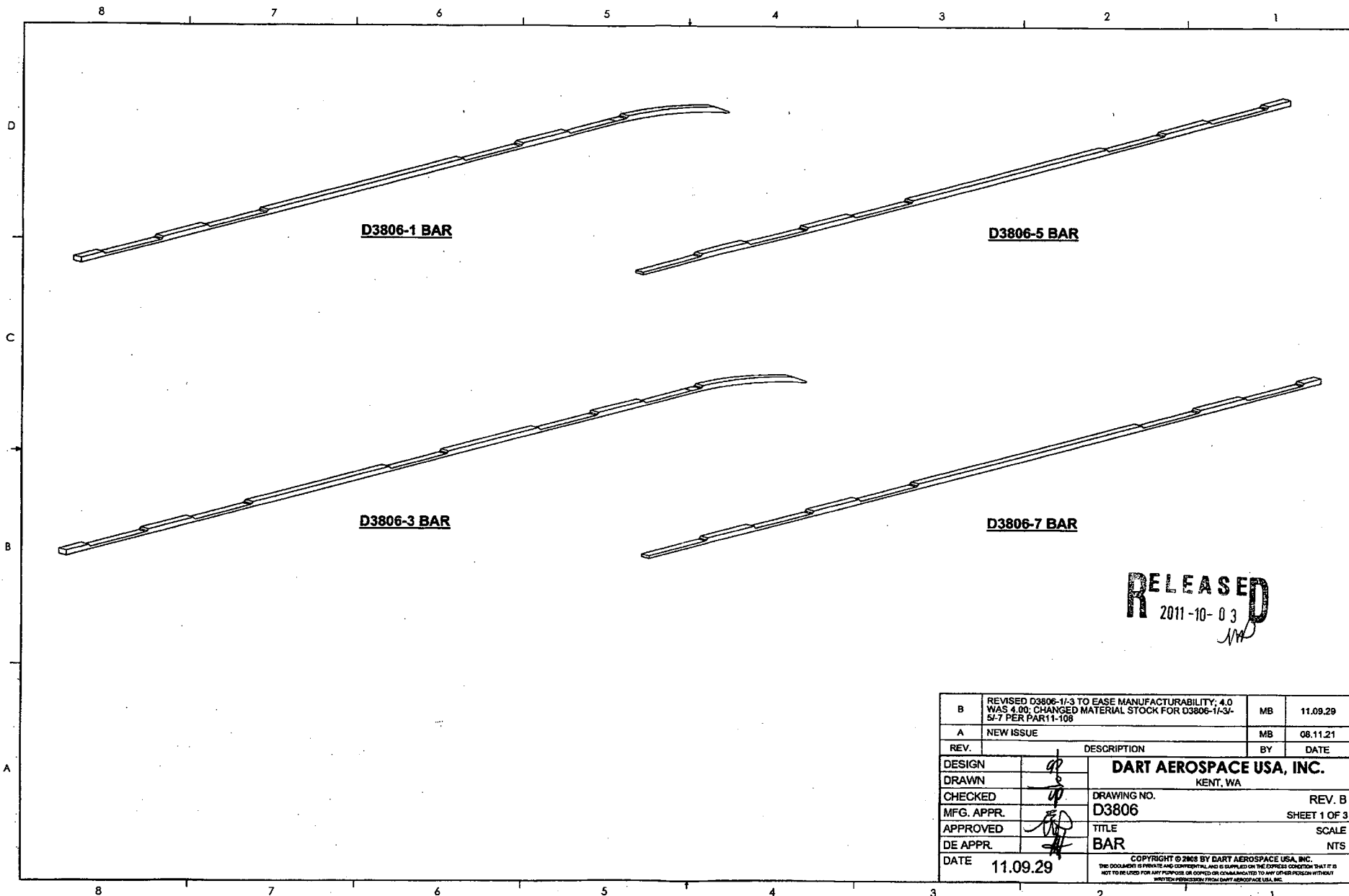
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

PRELIMINARY ISSUE

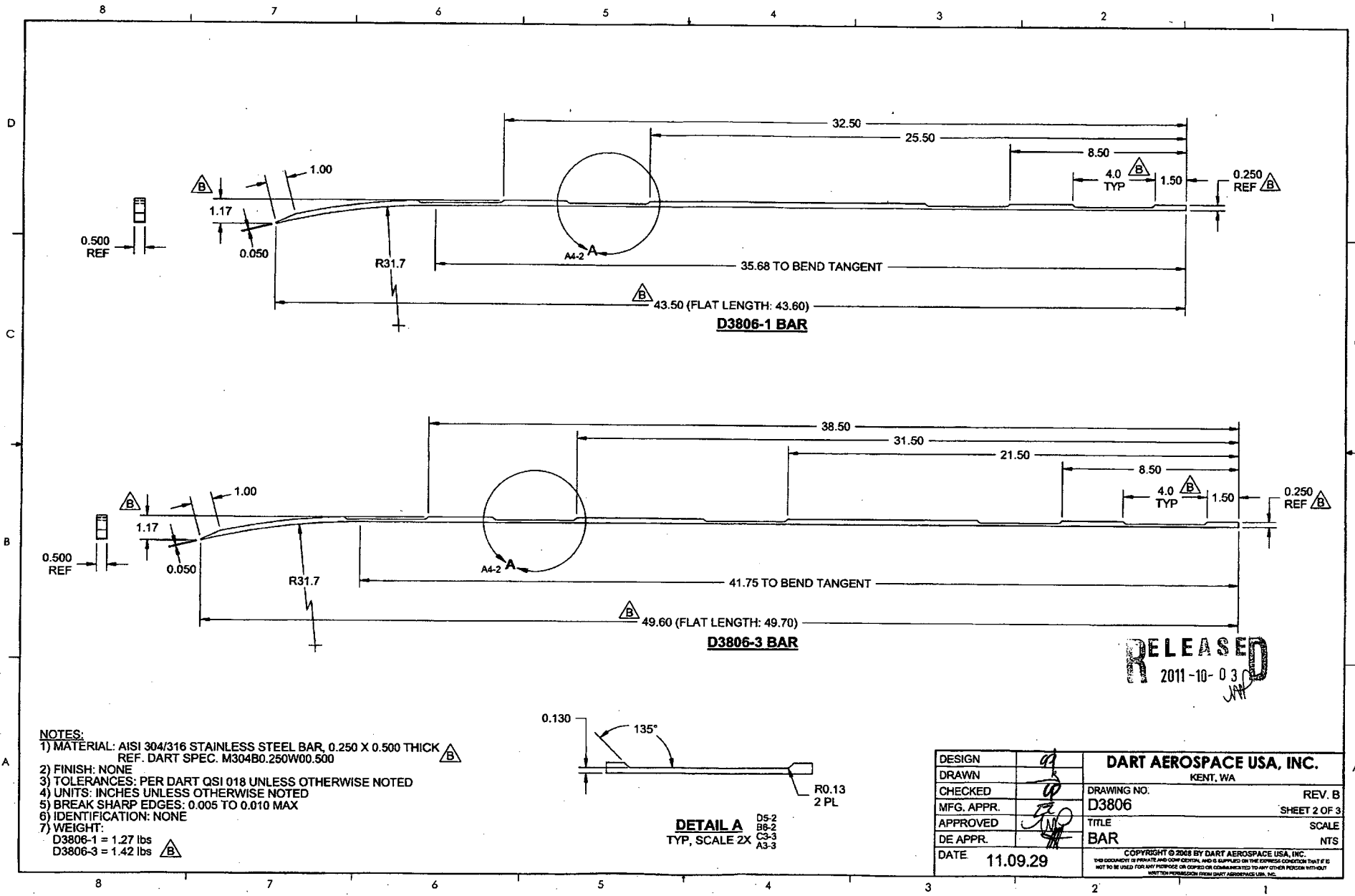
11.09.28

DESIGN	Q?	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 3 OF 3
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DE APPR.		BAR	NTS
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RELEASED
2011-10-03
W

B	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PART 11-108	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JP</i>	D3806	SHEET 1 OF 3
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	BAR	NTS
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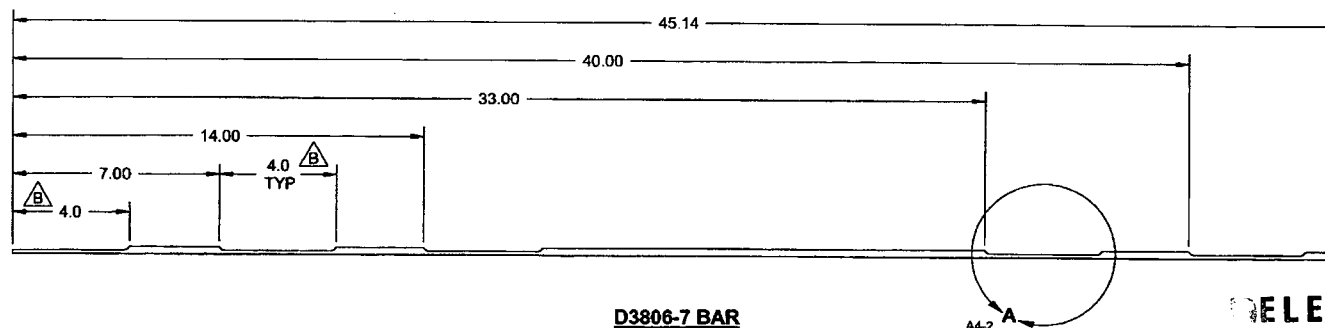
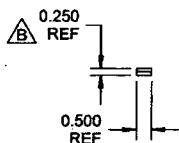
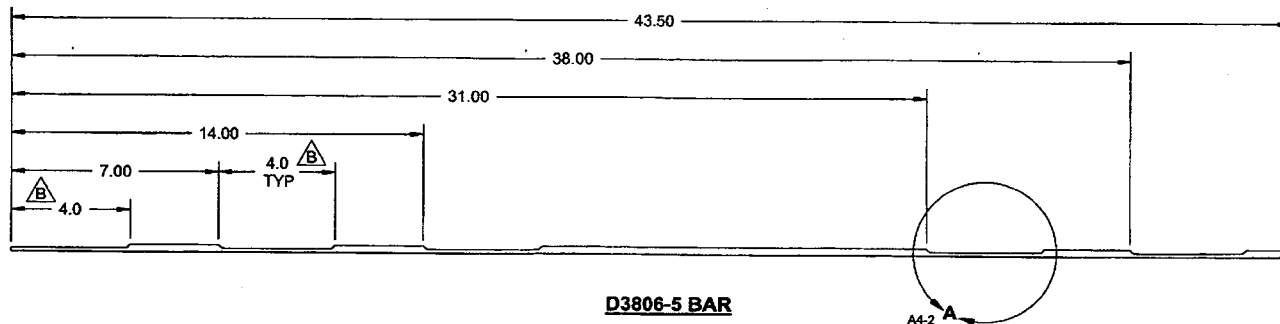
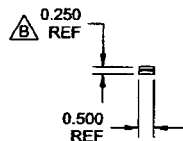


RELEASED
2011-10-03
JH

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK $\triangle B$
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs $\triangle B$
D3806-3 = 1.42 lbs $\triangle B$

DESIGN	41	DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	JP	DRAWING NO. D3806	REV. B
MFG. APPR.	JP	SHEET 2 OF 3	
APPROVED	JP	TITLE BAR	SCALE NTS
DE APPR.	JP	DATE 11.09.29	

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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK REF. DART SPEC. M304B0.250W00.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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